

Date: Thursday, 9/14/2006 1:08:16 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER BUSHING
Job Number : 28597	
Estimate Number : 10826	
P.O. Number : N/A	Part Number : D23273
This Issue : 9/14/2006 S.O. No. : N/A	Drawing Number : D2327 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 28073	Material : N/A
Written By : <u>JA</u>	Due Date : 9/21/2006
Checked & Approved By : <u>JA 06 09 14</u>	Qty: <u>100</u> Um: Each
Comment : Est. F 05/11/02 Removed 303 SS KJ/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R0375	304 SS ROUND BAR
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Comment: Qty.: 0.1641 f(s)/Unit Total: 6.56401(s)
 Inventory 184 304 .375 X .065 WALL
 Material: AISI 304 Round Bar Ø0.375"
 (M304R0.375) Batch: M18993
M10087 JA 06/10/11

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 Turn per Folio FA232 and Dwg D2327
 Deburr JA 06/10/11 100

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE JA 06/10/11 100

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK JA 06/10/11

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: 5140 JA 06/10/12 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: RP Date: 06/10/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER BUSHING

Job Number: 28597

Part Number: D23273

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(188)

Comment: FINAL INSPECTION/W/O RELEASE

06/10/12

Job Completion



U 06/10/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

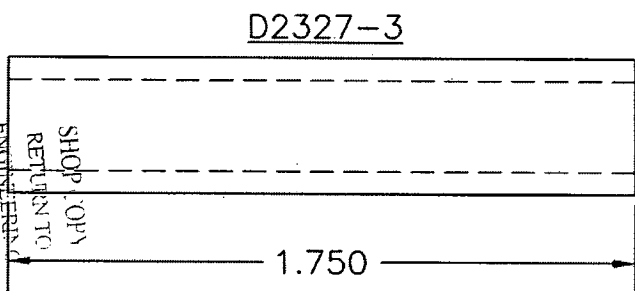
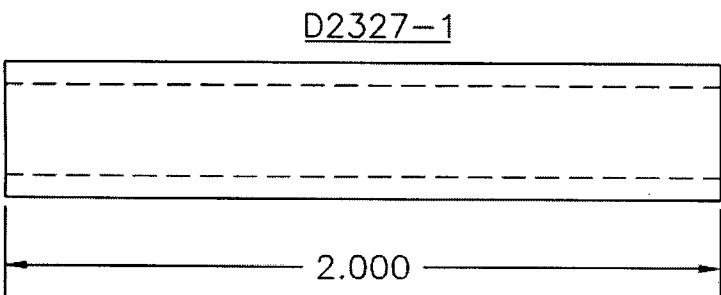
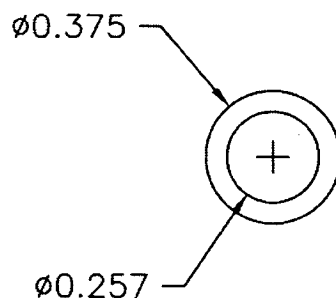
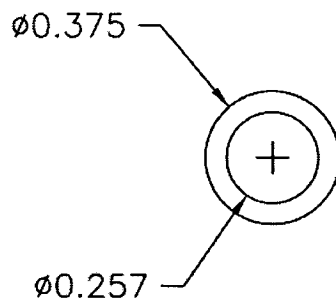
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
03.05.21

DESIGN	DRAWN BY	DART AEROSPACE LTD	
BW	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
<i>[Signature]</i>	<i>[Signature]</i>	D2327	SHEET 1 OF 1
DATE	TITLE	SCALE	
03.05.13	SPACER BUSHING	2:1	
A	94.12.17	NEW ISSUE	
B	95.12.06	LENGTH CHANGE	
C	03.05.13	303 SS SPEC ADDED	

**NOTE:**

- 1) MATERIAL: $\varnothing 0.375$ AISI 303 ROUND BAR (REF DART SPEC. M303R0.375) OR $\varnothing 0.375$ AISI 304/316 SS 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
28597

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